

Date: Tuesday, 27/01/2009 8:44:16 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	OUTER TUBE
Job Number :	45261		
Estimate Number :	13499		
P.O. Number :		Part Number :	PB6743001197
This Issue :	27/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.16
First Issue :	//	Project Number :	N/A
Previous Run :	41483	Drawing Revision :	B1
	Type :	Material :	
	MACHINED PARTS	Due Date :	09/02/2009
Written By :		Qty:	4
Checked & Approved By :	<u>MF 09-01-27</u>	Um:	Each
Comment :	Est Rev:A 08-07-24 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6T1750W065	6061T6 RDTUBE 1.750 X 0.65W
-----	------------------	-----------------------------



~~18188 X 4 feet~~
~~108659 X 4 feet~~



Comment: Qty.: 4.3864 f(s)/Unit Total : 17.5455 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: 109937~~109397 X 4 feet~~

28 09/01/29

2.0	BAND SAW	BAND SAW
-----	----------	----------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- cut to length as per dwg

2-cut a 27 degree angle on one end of tube as per dwg

2- deburr

28 09/01/30

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------

**Comment:** CONVENTIONAL MILLING MACHINE

1- drill holes and mill slot as per dwg PB67-43001

2- deburr

28 09/01/30

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



0.25" will be done 2 ass'y per M. B. 09-01-30

**Comment:** INSPECT WORK TO CURRENT STEP

209-07-30 (4)

5.0	PB6743001199	Outer Tube End Cap
-----	--------------	--------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Outer Tube End Cap

batch: 341571 ✓

209-07-03

(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 8:44:16 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER TUBE

Job Number: 45261

Part Number: PB6743001197

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1-Weld end cap as per dwg PB67-43001
2-grind end cap flush

Cpl 09-02-03

(x4)

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/02/03

(x4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/03 (x4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Cpl 09-02-04

10.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

09/02/05

Job Completion



MF 09-02-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

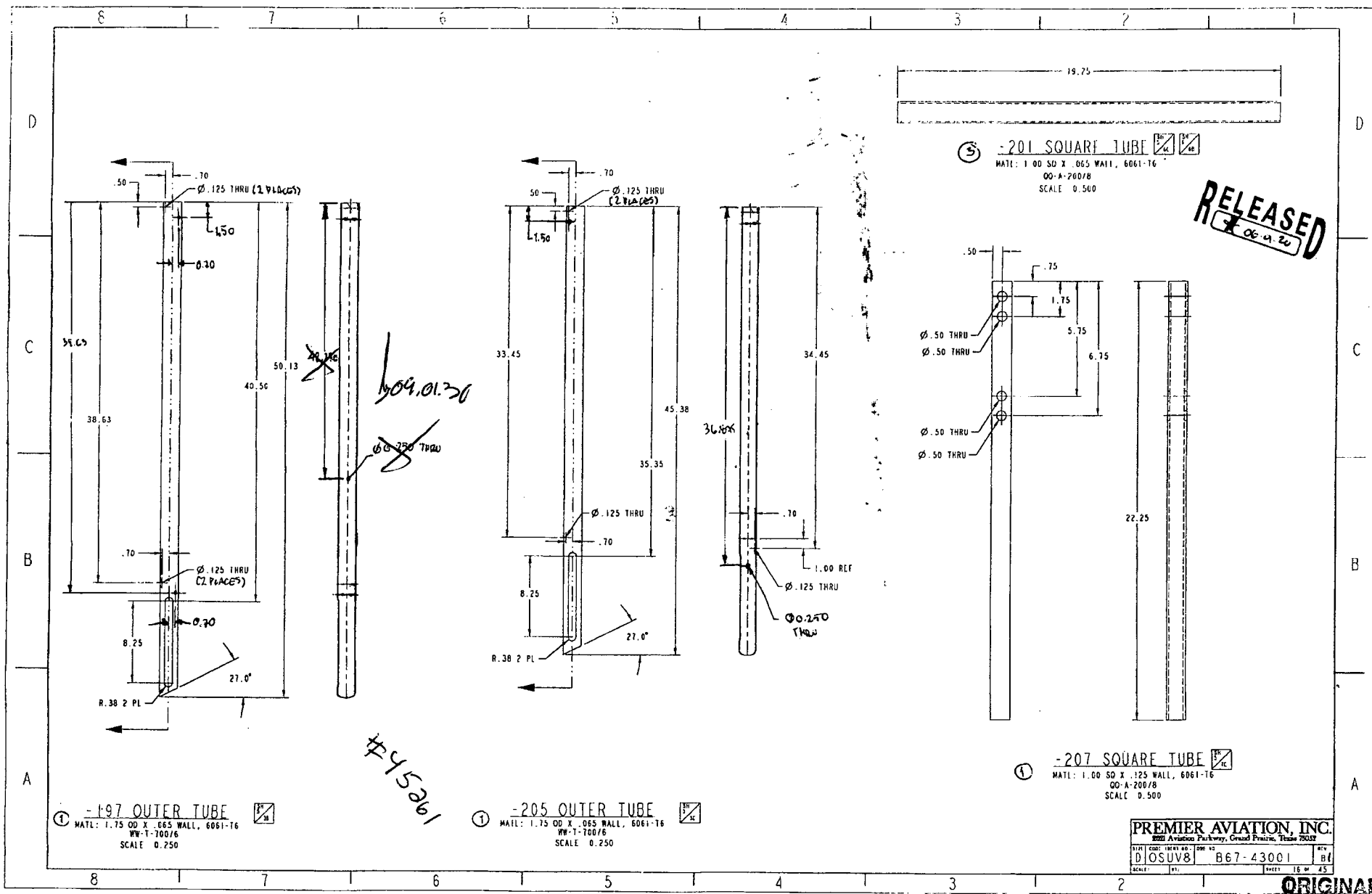
361-43001 Rev: B1
pg 45
FIRST ARTI

☒ **First Article** ☐ **Prototype**

Measured by: <i>8/8</i>		Audited by: <i>[Signature]</i>		Prototype Approval: N/A	
Date: <i>09/01/30</i>		Date: <i>09.02.03</i>		Date: N/A	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

88 6
7 88
70.7



PREMIER AVIATION, INC.
3000 Aviation Parkway, Grand Prairie, Texas 75052
ITEM CODE: 104140-100-10
D OSUV8 B67-43001 B1
SCALE: 1:1 IN: 1:1 SHEET 16 OF 45

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action : Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries